

## 3D Printer User Manual

## | Important Statement



Thank You for choosing KOKONI 3D printer. We hope You enjoy the experience!

We strongly recommend you reading this manual carefully before operating your printer. Using the printer indicates that you have both read this manual and agreed to the safety instructions listed below.

KOKONI is dedicated to providing the best possible service. To reach our customer support, please feel free to contact us by phone or email provided at the end of this manual.

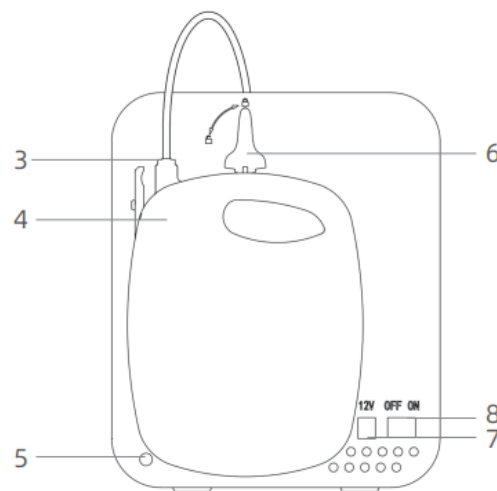
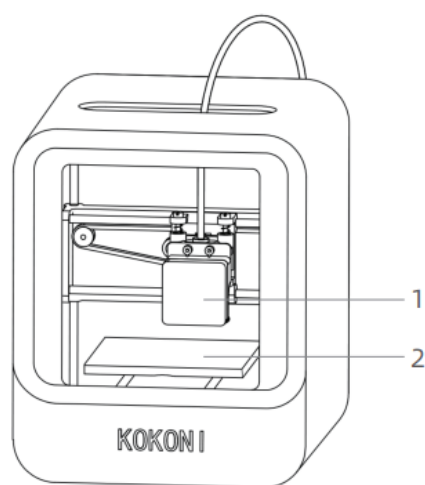
For better experience, please visit our official website [www.kokoni3d.com](http://www.kokoni3d.com) for hardware and software related information, contact information, operating and maintenance information, and so on.

Moxin (Huzhou) Technology Co. Ltd reserves the right to revise and construe this user manual.

## | IMPORTANT SAFETY INSTRUCTIONS

1. Do not attempt to use the printer for any other unintended purposes not mentioned in the manual, as doing so may result in personal injuries or property damage.
2. Do not position the printer near any combustibles, explosives or heat sources. A well-ventilated, cool and dustless environment would be perfect.
3. Do not place the printer in a vibrating or unstable environment. The shaking of machine may cause print quality issue.
4. Please use the power adapter we provide to connect the printer to a nationally accredited two-hole power outlet, don't use other adapters to connect the printer. To reduce the risk of fire or electric shock, do not expose the printer to rain or moisture.
5. Do not wear woven gloves while operating the printer as they could be rolled in via the movable parts, which could result in bodily body injuries.
6. Keep any part of your body off the moving nozzle and the printing platform, while the printer is operating.
7. The models printed out by the printer are not edible.
8. Do not loosen any screws of the machine to prevent electrical shock.
9. To guarantee the printing quality and a standard service life of the printer, please use the filament we recommend.
10. Maintain the printer on a regular time basis, switch off the printer to clean the shell with a piece of dry cloth, clear up filament slag in the printing chamber by tweezer and check whether there are some foreign objects on the belt.
11. To avoid injuries, it is forbidden for children aged 10 or less to operate alone.
12. Users should strictly comply with the relevant local laws and regulations of any residing region or country, observe professional ethics and ensure safety while using this product. Otherwise, they should bear corresponding legal liability.

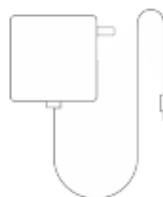
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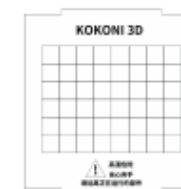
1. Printing nozzle assembly
2. Printing platform
3. Filament outlet
4. Filament chamber
5. Network configuration button
6. Filament replacement switch
7. Power input
8. Power switch



Tweezer \*1



Power adapter\*1



Printing plate\*1  
(Pre-assembled)

Note: Please wait till the white indication light stop flashing before operating the device!

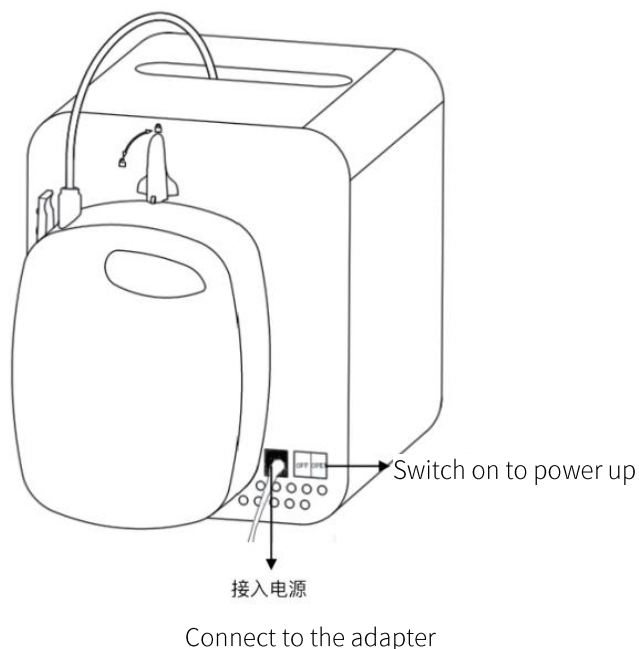
## | Product Specifications



Description	Model No.	Dimensions	Printing size
KOKONI 3D Printer	KOKONI-EC1	189*272*231 mm	100*100*58 mm
Execution standard	Net weight	Rated voltage/Current	Rated power
GB 4943.1-2011	3.1 kg	DC12V/5A	60W
Forming technique	Number of nozzles	Nozzle diameter	Nozzle temperature
FDM/FFF	Single nozzle	0.4 mm	≤260°C
Printing speed	Printing layer thickness	Compatible file format	Raw material of filament
80 mm/s (MAX)	0.04~0.35 mm	STL., OBJ, etc.	Modified PLA

## | Environmental Specifications

Environmental condition	Recommended value	Allowed value
Temperature	18~25°C	10~27°C
Humidity	Relative humidity 20~60%	Relative humidity 10~70%
Altitude	Not applicable	0~2000 m



1. After turning on the Power switch, there will be a beep sound and the indicating light in white color will start to flash (to ensure better print quality, please place the printer on an flat and stable place).

2. Wait for the printer to perform its power-on self-test procedure. This may take about 30 to 60 seconds. Then, the white indicating light will stop flashing, and the printer is ready for use.

### Tips:

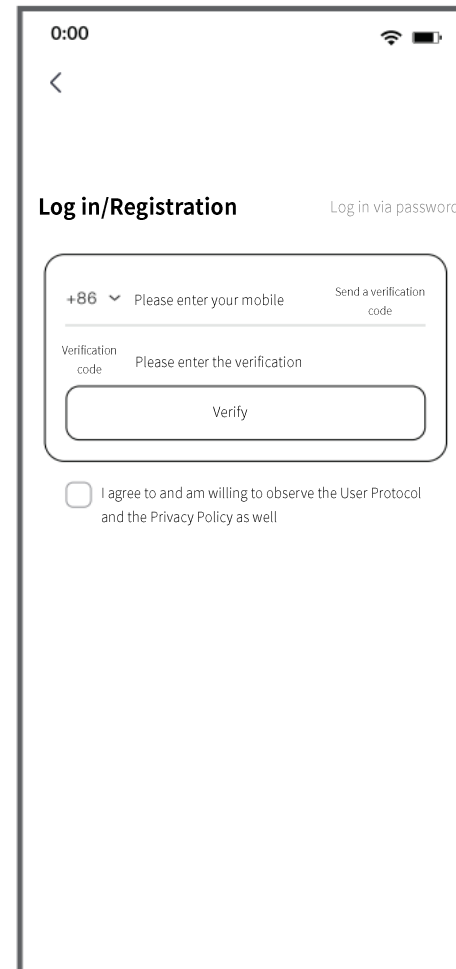
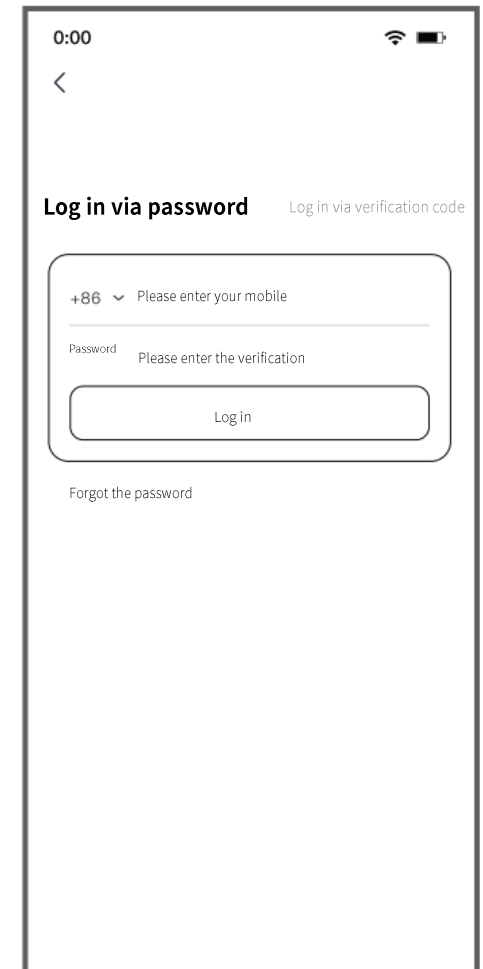
You can download the printer control KOKONI App during the power-on self-test of the printer.

## | Indicator status

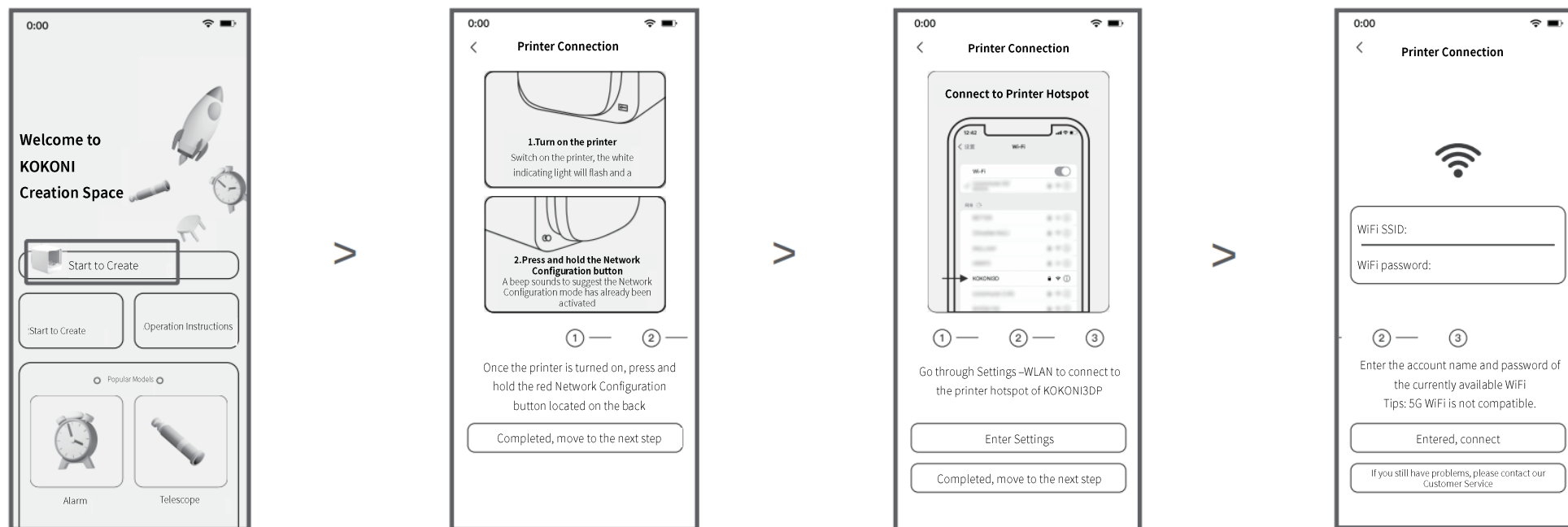
Printer status	Indicator light	Status of indicators
Printer self-inspection	White	Flash
Printer network configuration	White	Off
Printer normal condition	White	On
Incorrect WiFi password	Orange	On
Filament replacement	Orange	On
Maintenance mode	Orange	On



1.Scan the QR code to download the KOKONI App

A mobile app interface for login and registration. At the top, it says "Log in/Registration" with a link "Log in via password". Below is a form with two sections: the first for mobile number (country code "+86", input field "Please enter your mobile", and a "Send a verification code" button) and the second for verification (input field "Please enter the verification" and a "Verify" button). At the bottom, there is a checkbox and text: "I agree to and am willing to observe the User Protocol and the Privacy Policy as well".A mobile app interface for login. At the top, it says "Log in via password" with a link "Log in via verification code". Below is a form with two sections: the first for mobile number (country code "+86", input field "Please enter your mobile") and the second for password (input field "Please enter the verification" and a "Log in" button). At the bottom, there is a link "Forgot the password".

2.Register/Log in.



1. Add a printer.
2. Press and hold the Network Configuration button till it beeps, which indicates that the Network Configuration mode has been activated.
3. Printer hotspot connection: Go through Settings – WLAN to connect to the printer hotspot of (KOKONI3D-xxxx) with the password of 12345678.
4. Connection to users' WiFi: Return to KOKONI App and enter the SSID and password of the currently available WiFi at user's place to have KOKONI printer connected to the Internet.

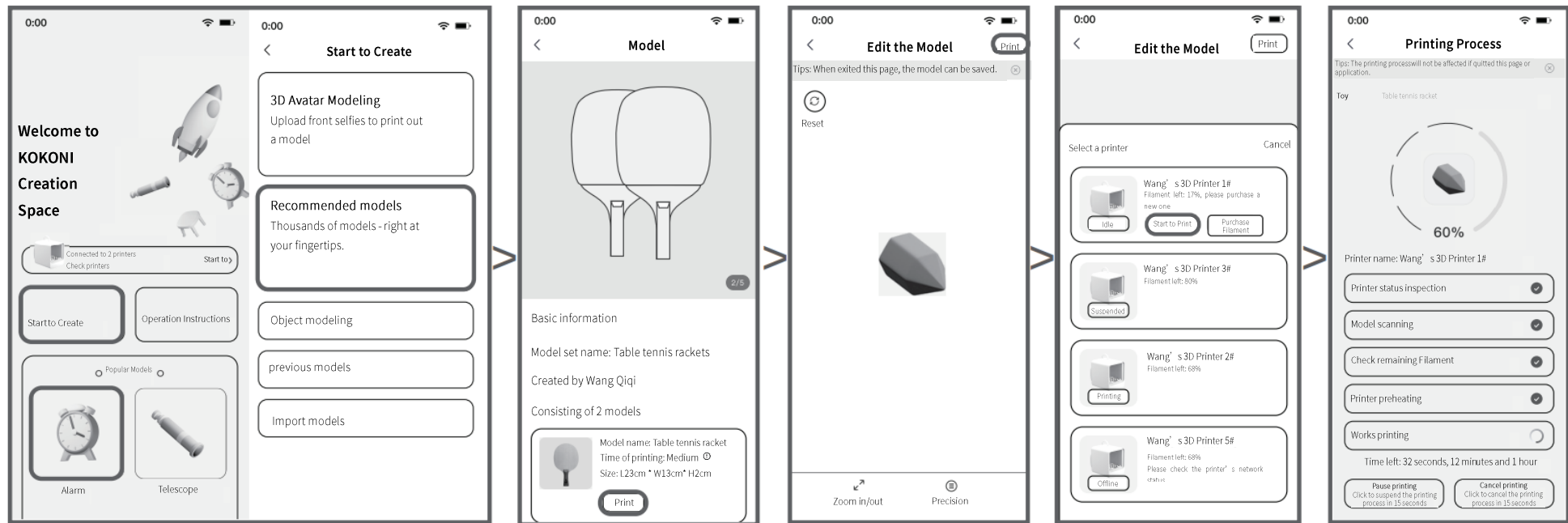
## Attention:

1. For some phone models, it would take some time to search for a hotspot, please wait/refresh or just turn off the WiFi function and restart it.
2. The following functions have to be turned off for some phone models: WiFi Security Inspection, WLAN+, Network Intelligent Selection, connect to the Best WLAN Network and Automatically Switch the Cellular Network.

If you encounter problems in WiFi network configuration, please check the following diagnosis procedure:

1. Confirm the WiFi account and password, and make sure the WiFi entered is the current environment WiFi instead of KOKONI3D hotspot.
2. Ensure that the network environment is good. If the problem still exists, change to another network. 5G WiFi is not compatible. For the WiFi network configuration instructions designed for smart phones of various models, please refer to the Operation Guidance of the App.



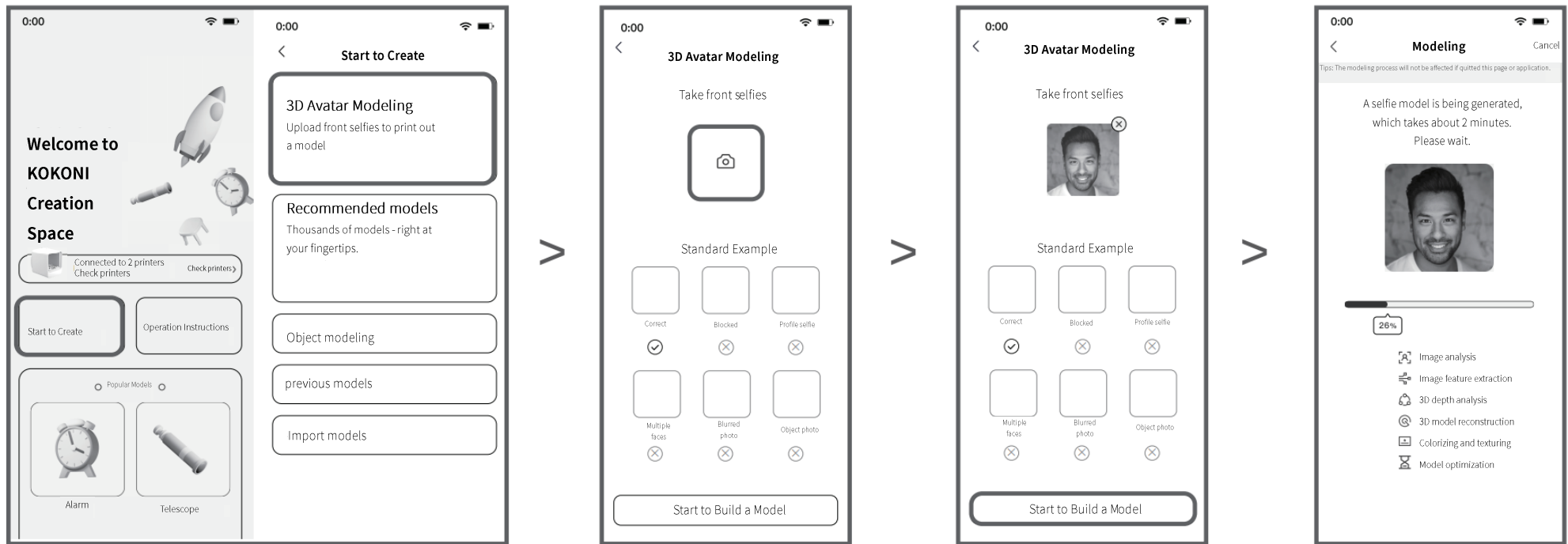


1. Browse a model:  
 (1) Home – Start to Create – Recommended Models.  
 (2) Home – Popular Models – Select a Model
2. Click "Print" on the model details page.
3. Click "Print" on the model editing page.
4. Select the printer and Click "Print" to print.
5. While printing, you can pause or cancel the printing task.

## Attention:

1. After printing starts, the printer usually takes about 2 minutes to heat up. Please wait patiently.
2. Under no circumstances should you touch any moving parts as injuries could be inflicted. Be aware of the hot nozzle. If anything goes wrong in the printing process, click Cancel to terminate printing or just unplug the power adapter. In such case, try not to make contact with either the nozzle or the printing bed.

## | 3D Avatar Modeling



1. Home – Start to Create – 3D Avatar Modeling

2. Click "Upload Photos"

3. Click "Start Modeling"

4. Wait for modeling finished, you can print it out then.

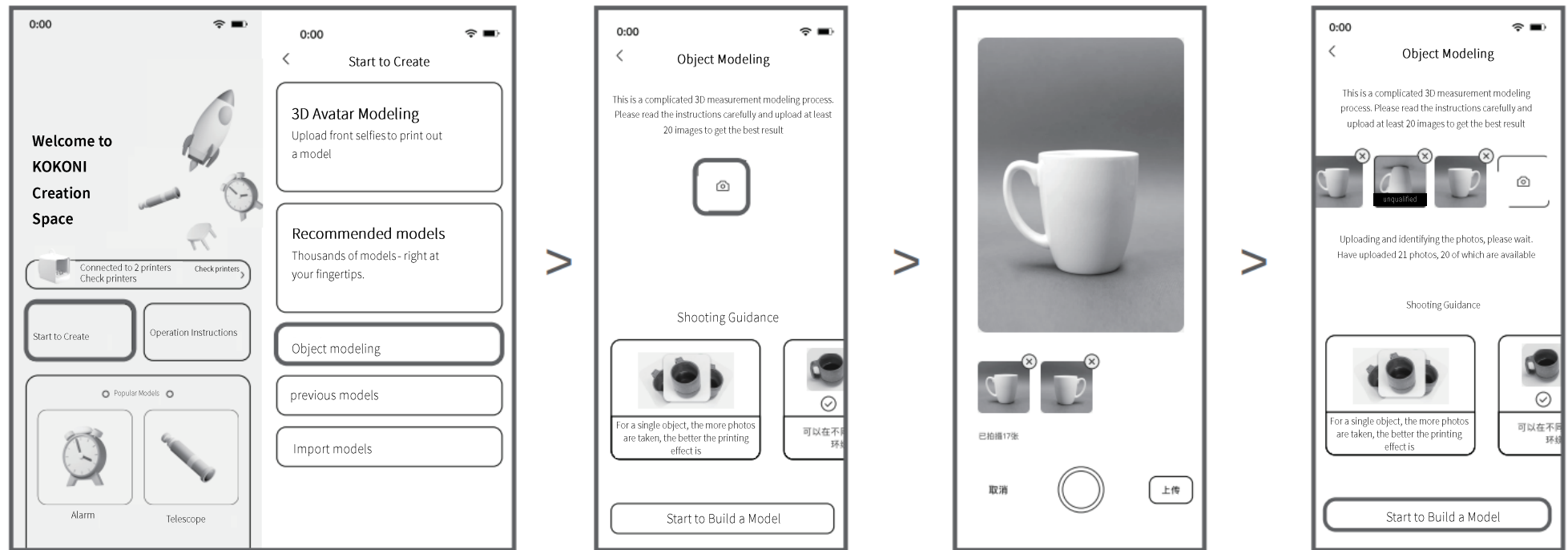
### Attention:

1. 3D Avatar modeling requirements: (1)Support selfie capturing or uploading photos via a smart phone; (2)When taking photos, light up the person sufficiently and make the person's face towards the camera without being blocked; (3)Don't put on hats when taking photos; (4)Do not take profile selfies; (5)Upload high definition photos; (6)Do not upload a photo of more than one person.

Please be noted that this function is only suitable for modeling living human being's faces.

2. If you are prompted with "no face", please change to a brighter shooting environment, remove your glasses, and take an unobstructed photo of your face.

3. If you are prompted with "Image format is not standard", please try to take pictures with your camera, and do not upload motion pictures such as GIFs.



1. Home – Start to Create – 3D Avatar Modeling

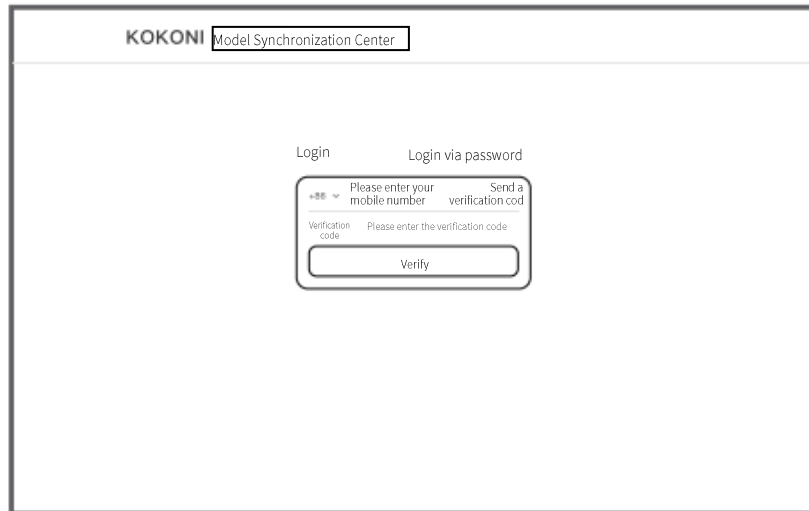
2. Click "Upload Photos"

3. Take photos around the object with each movement of the viewing angle less than 30 degrees

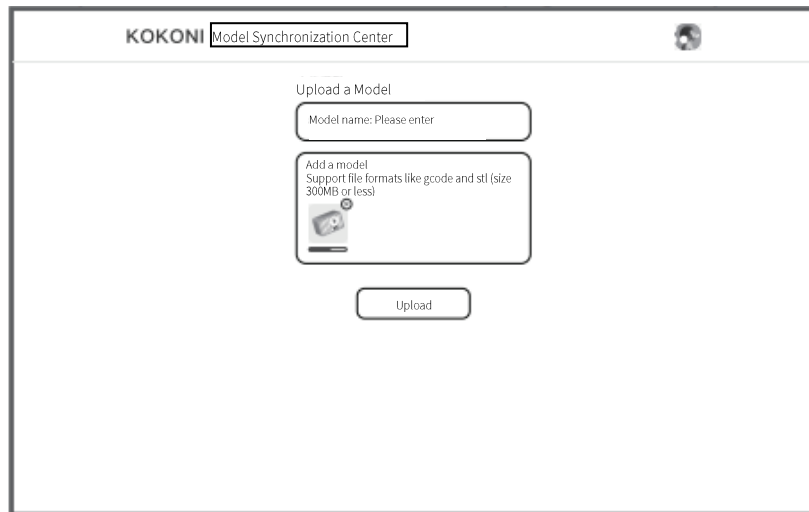
4. Taking at least 20 photos, and then then click "Start to Build a Model"

## Attention:

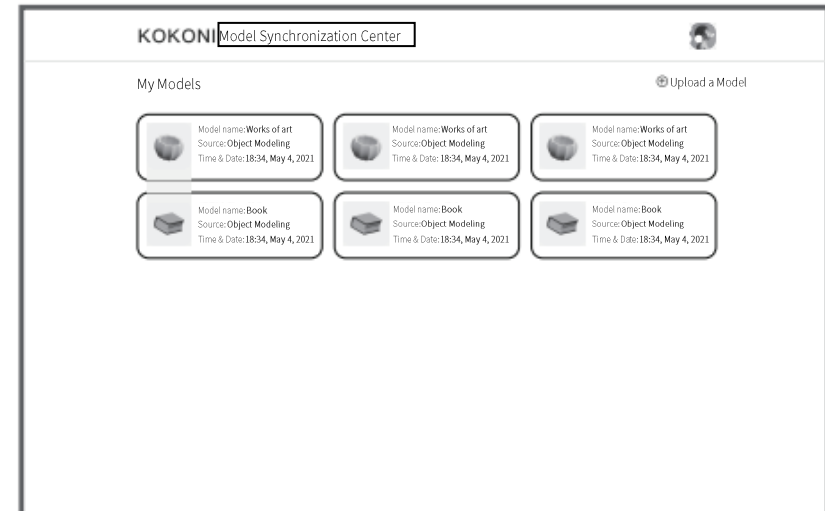
- Object modeling is based upon precise 3-dimensional measurement of 20~300 images taken around the object with each movement of the viewing angle less than 30 degrees and one overlaying another by more than 60%.
  - The system will automatically verify whether the uploaded photos are qualified or not. At least 20 qualified photos are needed for modeling.
- As reconstructed via a computer algorithm, the modeling process takes about half an hour in the background, and you can exit this page during the course of modeling. When finished, a message will pop up to notify you if the function of "Push Notification" is activated on. You can then check the model in "My Models".



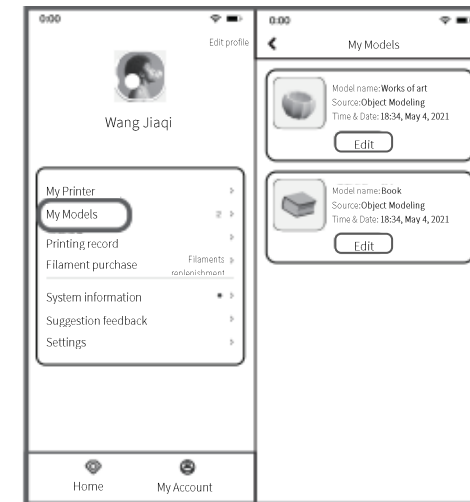
1. Access the KOKONI model synchronization website:  
<http://www.KOKONI.ltd/home/#/pages/modelSync/modelSync>



3. Upload the model



2. Enter "My Models" and click "Upload a Model" in the right upper corner

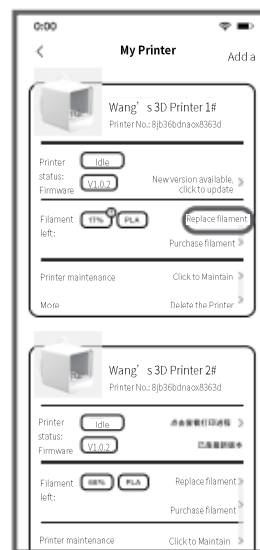


4. Go to "My Account" – "My Models" in the App to check uploaded models.

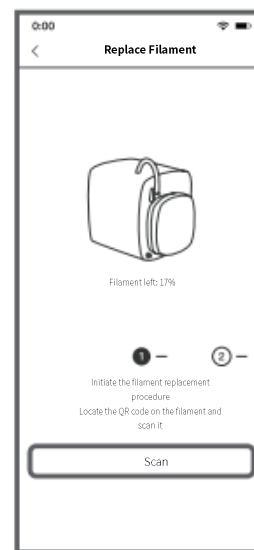
# | Filament Replacement



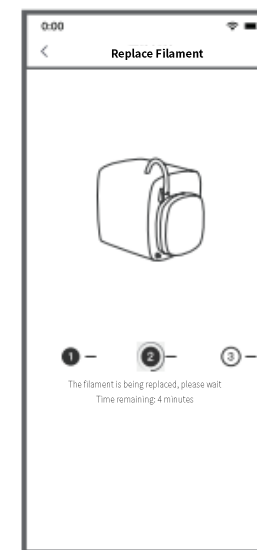
1.Go to "My Printer"



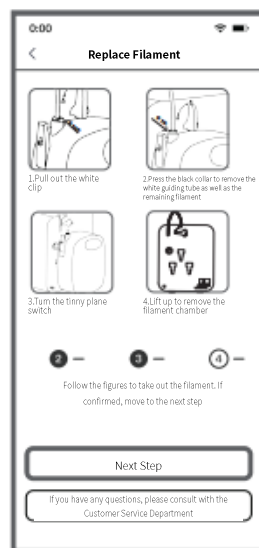
2.Click "Replace Filament"



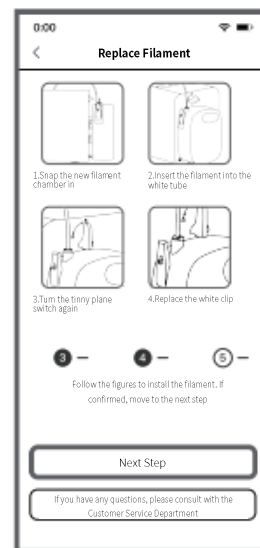
3.Scan the QR code on the filament box



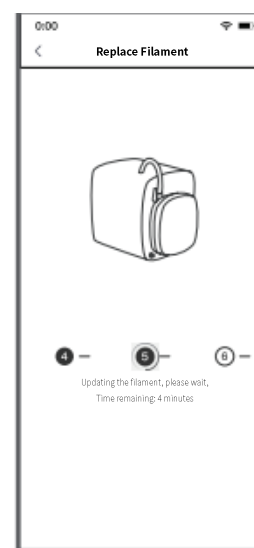
4.The printer is heated up to prepare for filament replacement



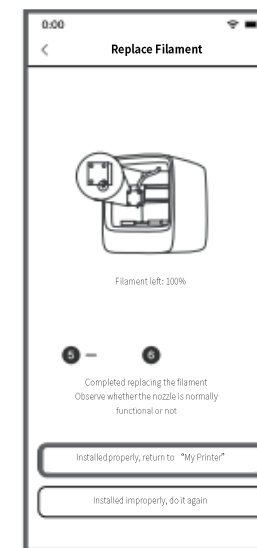
5.Refer to the figures as shown on Page 12 to uninstall the filament.box



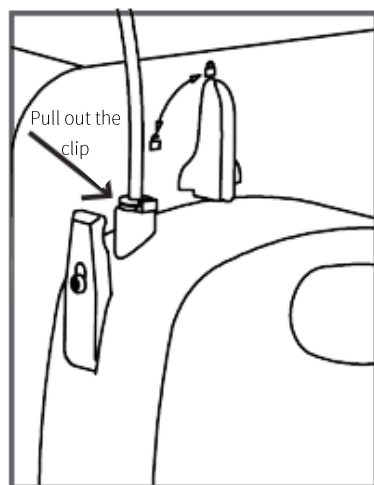
6.Refer to the figures as shown on Page 12 to attach the filament box to the printer.



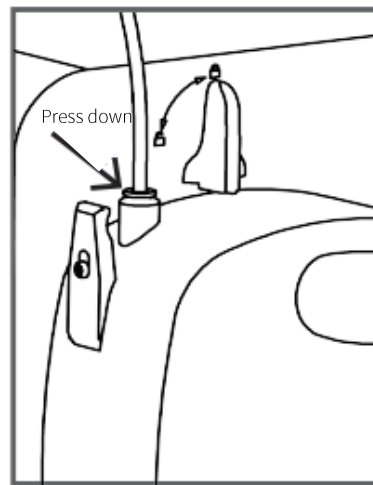
7.The filament is being loaded in, please wait.



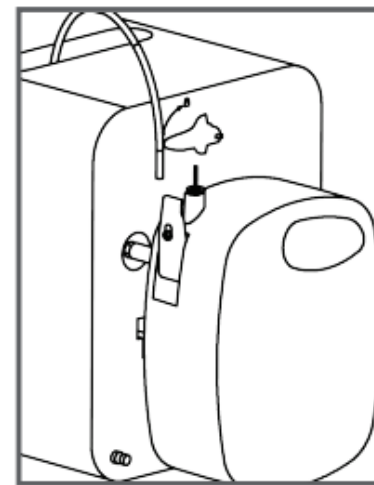
8.Filament replacement is finished.



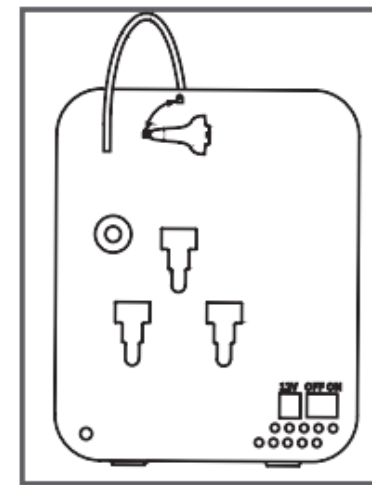
9. Pull out the white clip



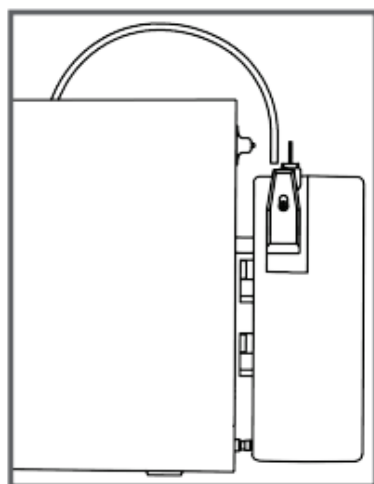
10. Press the black collar to remove the white guiding tube as well as the remaining filament



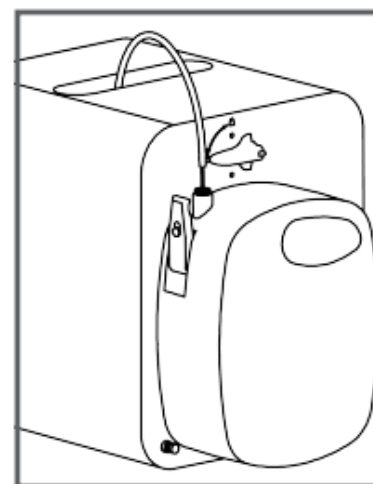
11. Turn the tiny plane switch



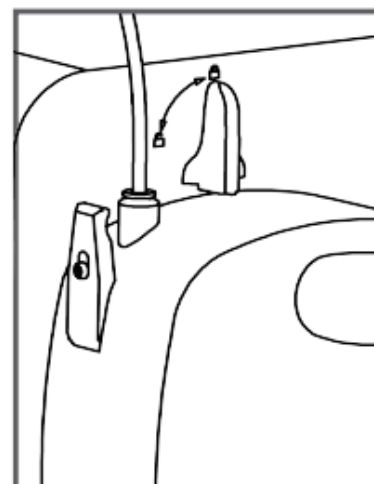
12. Lift up to uninstall the filament box.



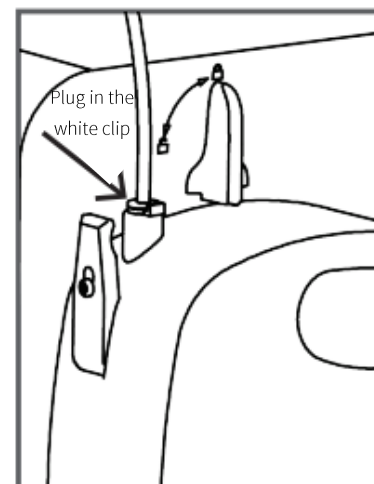
13. Snap the new filament box in.



14. Insert the filament into the white guidance tube



15. Turn the plane switch again

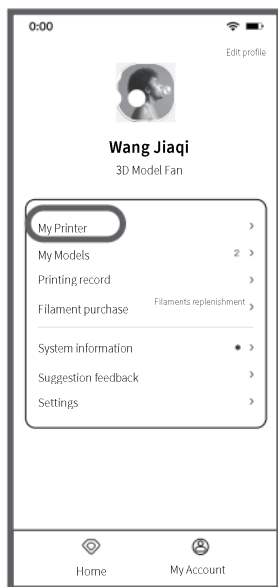


16. Plug in the white clip

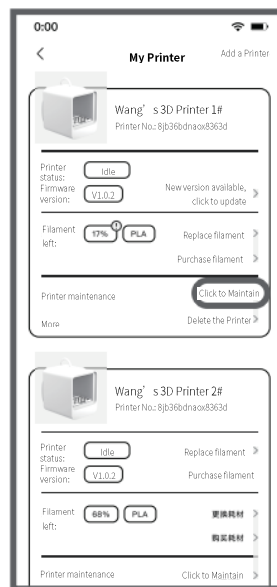
## | Printer Maintenance



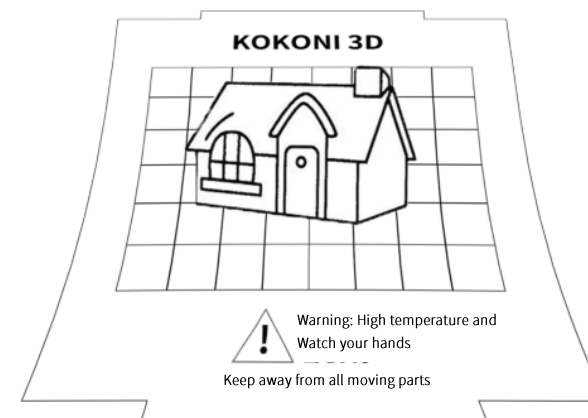
In case the model is unable to be taken out from the printbed, or any foreign objects need to be removed from the printer, click "My Printer" in the App for maintenance. The printer will automatically heat up and push the printing bed outwards.



1.Go to "My Printer"

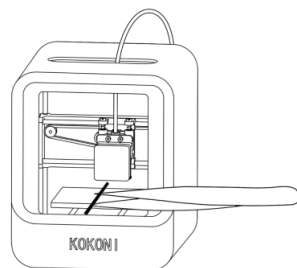


2.Click "Maintain "

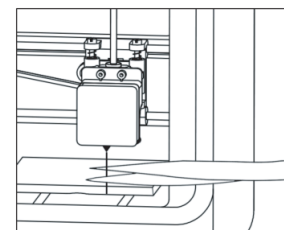


3.Lift up the base plate with the model on to take it out from the cabinet and just bend the former a little bit to separate it from the latter (suggested to change the base plate every 3~6 month)

## | Cleaning Up



1.Clear the cabinet with tweezers



2.As the nozzle needs to heat up to 200℃ more or less before started to print, it is normal to see surplus materials coming out.

Q: How to make the surface of a model more smooth?

A: To make a model look shiny and feel smooth, you need to use sand paper or other tools to polish it. You can also select "High" in the precision setting to make better surface finishing. If the condition is intolerable and difficult to fix, contact the Customer Service Department.

Q: Is the printer compatible with other filaments?

A: Not yet, please use KOKONI modified PLA filament.

Q: How to change the filament?

A: Launch the KOKONI App and go through "My Printer" –"Replace Filament" to change it. More detailed instructions is shown on Pages 11~12 of the manual. Change the filament without KOKONI App could cause print quality issue or even damage the printer itself.

Q: Why doesn't the model stick onto the base plate?

A: When the first layer of a model doesn't stick to the base plate, apply a layer of glue to the base plate and do printing at a room temperature ranging from 20°C to 25°C as a proper temperature could prevent the base plate from bending over. Model warping is a normal phenomenon caused by the physical properties of the plastic itself, so printing in a warm environment can help to alleviate bottom warping.

Q: How many models can a reel of the filament make?

A: The reel of the filament is 70m, and the number of models it could make depends on the size of the models. Models in large size may need more filament. A more complicated model may consume more filament, too. On average, a reel of filament may print out about 20 simple models.

Q: Is it possible to resume the last printing task following a power failure?

A: Negative, once the power is out, the printing process ends.

Q: The connected printer becomes offline.

A: Reboot the printer and KOKONI App. If the printer still remains offline, delete it and reconnect the printer for network configuration.



## Hazardous Substance Declaration



Component	Hazardous or toxic substance or element					
	Lead (Pb)	Mercury (Hg)	Cadmium (Cd)	Hexavalent chromium (Cr6+)	Polybrominated biphenyls (PBB)	PBDE
Modified PLA filament	○	○	○	○	○	○
Printed circuit board (PCB)	×	○	○	○	○	○
Shell	○	○	○	○	○	○
Wire	○	○	○	○	○	○
Hardware	○	○	○	○	○	○
Power adapter	○	○	○	○	○	○

The said table is compiled according to the standards of SJ/T 11364.

○ Indicates that all homogeneous materials of the component in question contain the current hazardous substance less than the limit as provided in GB/T 26572.

× Indicates that at least one certain homogeneous material of the component in question contains the current hazardous substance above the limit as provided in GB/T 26572.

Notes: No batteries are needed by the printer.

### Warranty Period

1-year Limited Warranty for the printer and power adapter from the date of purchase;

3- months Limited Part Warranty for the Vulnerable parts( Extruder, Belt, Printing Platform Nozzle Module,etc.);

No Warranty for the Tools, Filaments, Printer Shell, User Manual, Warranty Card,etc.

### What Is Not Covered?

1. The warranty period expires;
2. The purchase voucher is invalid or not identical with the product model;
3. Either the purchase voucher or the warranty card becomes unidentifiable due to man-made damage;
4. Use, maintain or repair the printer unintendedly, or dismantle the hardware or alter the software without KOKONI's permission;
5. The circuit board of the printer has been ruined due to crash, soaking, falling down or other human factors;
6. Use components not certified by the manufacturer;
7. Damage caused by force majeure such as fires, lightning and floods;
8. The product ages or discolors normally along the process of operation;
9. Product gifts.

### After-sales Support

Please read the user manual and warranty card carefully before use. For any after-sales service, please priorly contact local seller or contact us via Email:Support@kokoni3d.com or Call (+86)400-900-1360/ 0086-572-8219691.

Please provide product Serial Number when apply for technical support.

FCC Statement:

This device complies with part 15 of the FCC Rules. Operation is subject to the following

two conditions: (1) This device may not cause harmful interference, and (2) this device

must accept any interference received, including interference that may cause undesired operation.

This equipment has been tested and found to comply with the limits for a Class B digital

device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the

user is encouraged to try to correct the interference by one or more of the following measures:

—Reorient or relocate the receiving antenna.

—Increase the separation between the equipment and receiver.

—Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.

—Consult the dealer or an experienced radio/TV technician for help.

Caution: Any changes or modifications not expressly approved by the party responsible

for compliance could void the user's authority to operate the equipment.

This equipment complies with FCC radiation exposure limits set forth for an uncontrolled environment. This transmitter must not be co-located or operating in conjunction with any other antenna or transmitter.

This equipment should be installed and operated with minimum distance 20cm between the radiator&your body.

Maintenance service center		Date of delivery for repair	
Reason behind fault			
Fault description			
Return evidence			
Repairer (signature)		Repairer (seal)	



Moxin (Huzhou) Technology Co., Ltd

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Email: [Support@kokoni3d.com](mailto:Support@kokoni3d.com)



To better serve our customers, the manual may be updated from time to time,  
we recommend scanning this QR code to view the latest manual. Thank you for your support.

Due to different models, the actual product and the picture may be a little different, please refer to the prevailed product; Software update page may change, please refer to the actual software page instructions; Moxin (Huzhou) Technology Co., LTD reserved all the right for final explanation.